

# Work Order ID 69923

Tuesday, May 24, 2011 1:41:19 PM



Page 1

Item ID: D3371-041

Accept



Setup Start



Revision ID:

Item Name: Pedal Lock Assembly

Stop



Start Date: 5/25/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: MFC

Date: 11-05-24

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

120



Small Fab

Small Fab

Memo

0.00

(3)

Sb 110602

- 1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
- 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
- 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
- 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R	262	Locktite	<u>110432</u>

130



Small Fab

Small Fab

Memo

0.00

(3)

Sb 110602

Assemble lanyard to cyclic sock as per Dwg D3384  
Identify as D3384-045

Dart Aerospace Ltd

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-041

PAR #: \_\_\_\_\_

Fault Category: Eng Design

NCR: Yes  No

DQA:

Date: 10/04/23

Resolution: Rework

Disposition: Rework

QA: NC Closed: ✓

Date: 10/04/23

NCR: 69923

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/24	120	2 part doesn't fit has to weld 4 holes + redrill to match part <u>D.3385-3</u>	<u>10/05/24</u> <u>QS1042</u>	-Plug Holes <u>Batch Recd</u> <u>M115778</u>	<u>✓</u> 10/05/24	S 10/05/24	<u>10/05/24</u> <u>QS1042</u>	<u>S</u> <u>10/05/24</u>
				-Ground Weld Flush	<u>✓</u> 10/05/24	S 10/05/24		

NOTE: Date & initial all entries

**Work Order ID 69923**

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



Small Fab

0.00

(3)

Small Fab

Memo

0.00

Small Fab

- 1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.  
 2- Identify as D3371-041 & attach keys  
 3- Record the Key Number on page 4

SB 1106103

150



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

S 1106103

(X3)

160



Identify as per dwg &amp; Stock Location:

0.00

Packaging

Memo

0.00

11/6/3 SP3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 69923**

Tuesday, May 24, 2011 1:41:19 PM



Page 3

Item ID: D3371-041

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Stop



Start Date: 5/25/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

170



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp



  
11-06-03

Key record

C420A

C420 A

e 420 A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Picklist Print

Tuesday, May 24, 2011 1:41:16 PM

Page 1

**Work Order ID:** 69923



**Parent Item:** D3371-041



**Parent Item Name:** Pedal Lock Assembly

**Start Date:** 5/25/2011

**Required Date:** 6/2/2011

**Start Qty:** 3.00

**Required Qty:** 3.00

**Comments:** IPP Rev: A Removed from 9 Digit 06-03-10 KJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, May 24, 2011 1:41:16 PM

Page 2

Work Order ID: 69923



Parent Item: D3371-041



Parent Item Name: Pedal Lock Assembly

Start Date: 5/25/2011

Required Date: 6/2/2011

Start Qty: 3.00

Required Qty: 3.00

CBL-460



Loop Sleeve

Purchased No

130 Each 82.0000

2

6

Sb 1166103

D2728-7



Dart Logo label

Manufactured No

Location ST284  
116953

120 Each 0.0000

0

0

Sb 1166103

D3371-1



Pedal Lock Base

Manufactured No

120 Each 0.0000

1

3

B 70040

(3) Sb 1166103

D3371-3



Pedal Lock Cover

Manufactured No

120 Each 0.0000

1

3

B 69634

Sb 1166103

D3373-7



Cam Lock

Manufactured No

120 Each 0.0000

1

3

B 22160

Sb 1166103

D3384-1



Cyclic Sock

Manufactured No

130 Each 0.0000

1

3

A 70032

Sb 1166103

D3385-3



Hinge

Manufactured No

120 Each 109.0000

1

3

22387

Sb 1166103

Location ST051

Loc Qty 109

Loc Code

ST051

109

3

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, May 24, 2011 1:41:17 PM

Page 3

Work Order ID: 69923



Parent Item: D3371-041



Parent Item Name: Pedal Lock Assembly

Start Date: 5/25/2011

Required Date: 6/2/2011

Start Qty: 3.00

Required Qty: 3.00

HX-81



Purchased

No

140

Each

27.0000

1

3

1/4"-20 SHCS 3/8" long



SB 1106103

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST390	27	
114383	27	3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

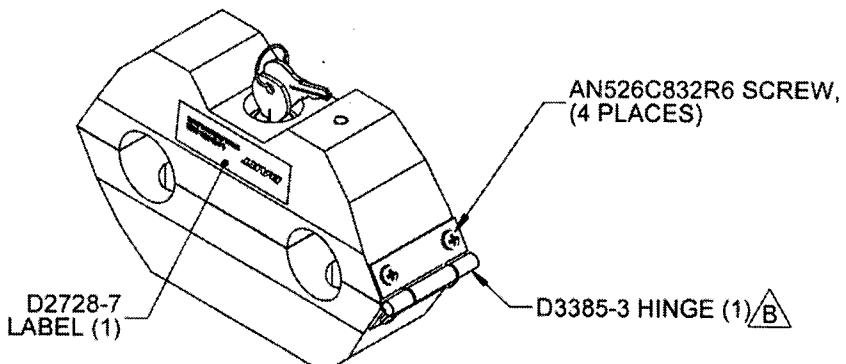
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

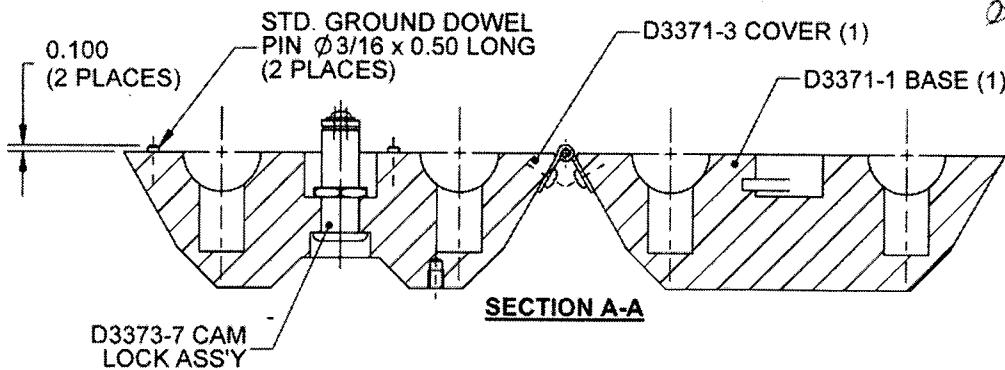


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3371	SHEET 1 OF 4
DATE	05.03.22	TITLE	SCALE
		PEDAL LOCK	1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

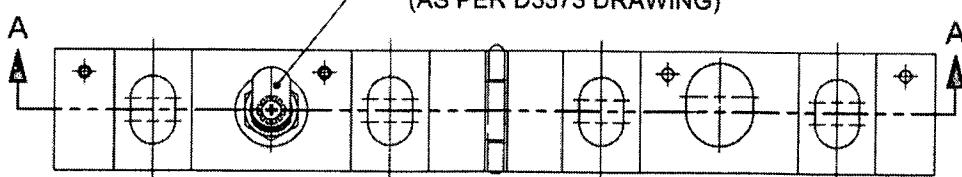


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED  
05/04/28



D3371-5 CAM (1),  
AND SQUARE WASHER SPACER (1),  
EXTERNAL TOOTH LOCK WASHER (1),  
#10-32 UNF PAN CROSS HEAD SCREW (1)  
(AS PER D3373 DRAWING)



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3371
DATE	05.03.22	TITLE PEDAL LOCK

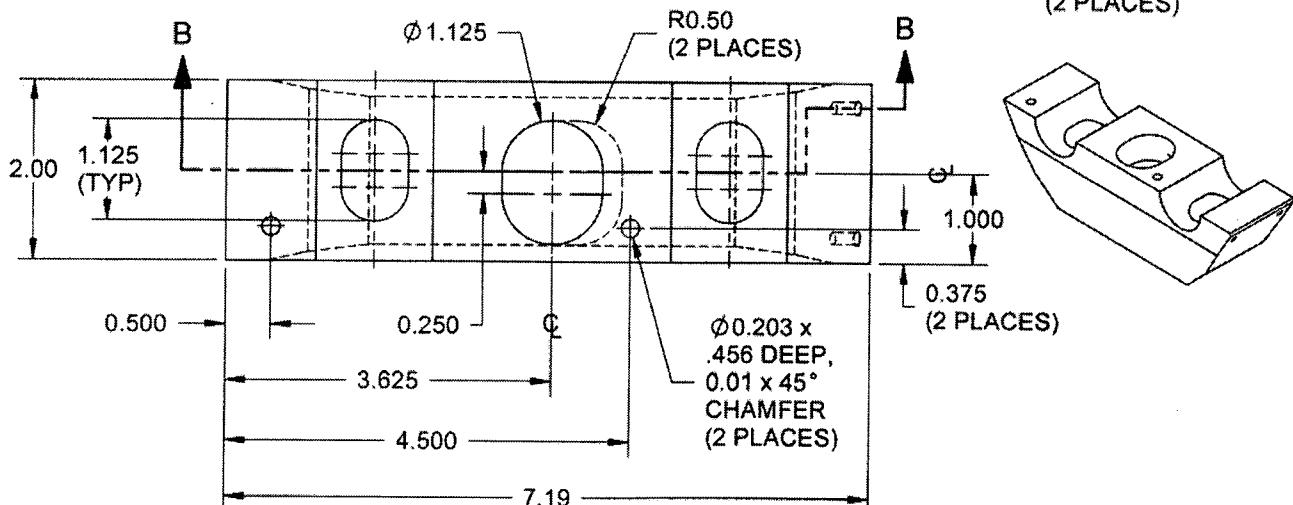
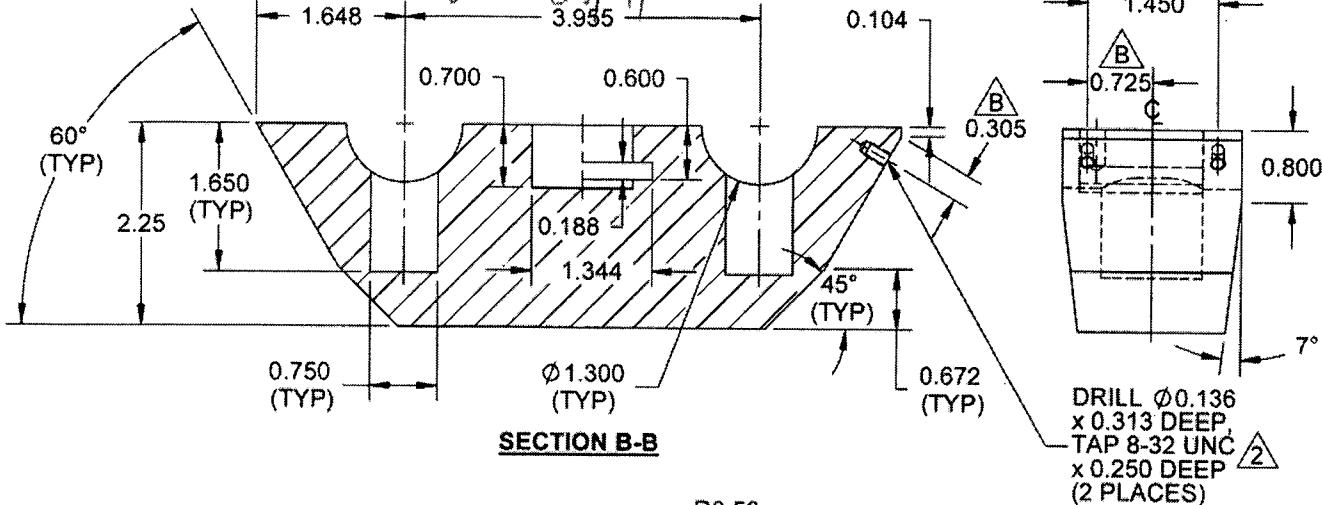
REV. B

SHEET 2 OF 4

SCALE

1:2

RELEASED  
*69923*



### D3371-1 BASE

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
  - 2) COVER INSIDE HOLES PRIOR PAINTING
  - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 69923*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

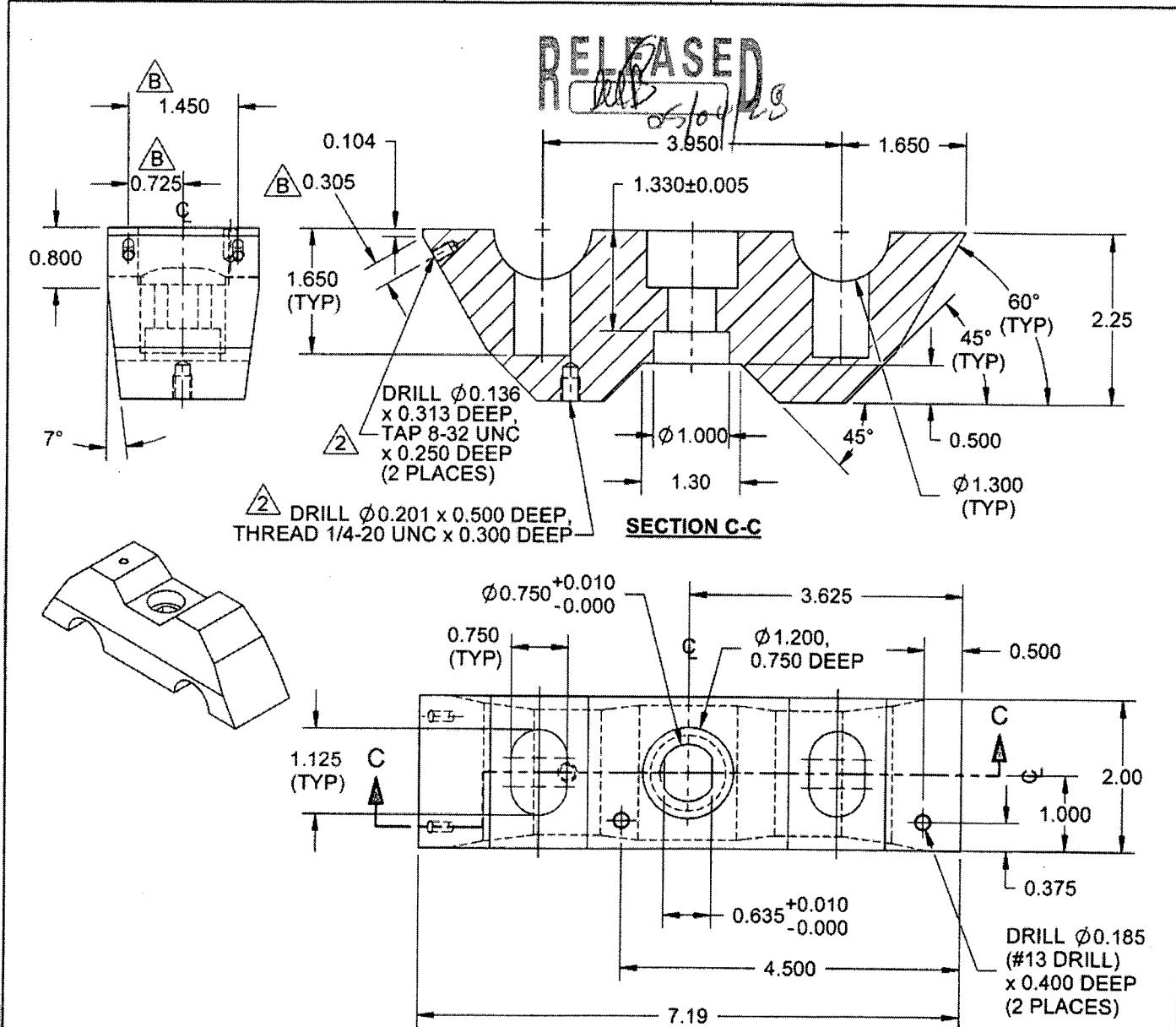


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	05.03.22	TITLE	PEDAL LOCK

SHEET 3 OF 4

SCALE

1:2



### D3371-3 COVER

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

*L6992*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

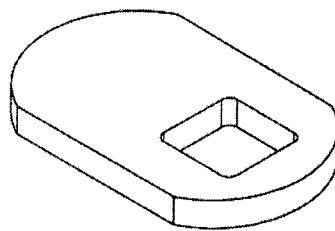
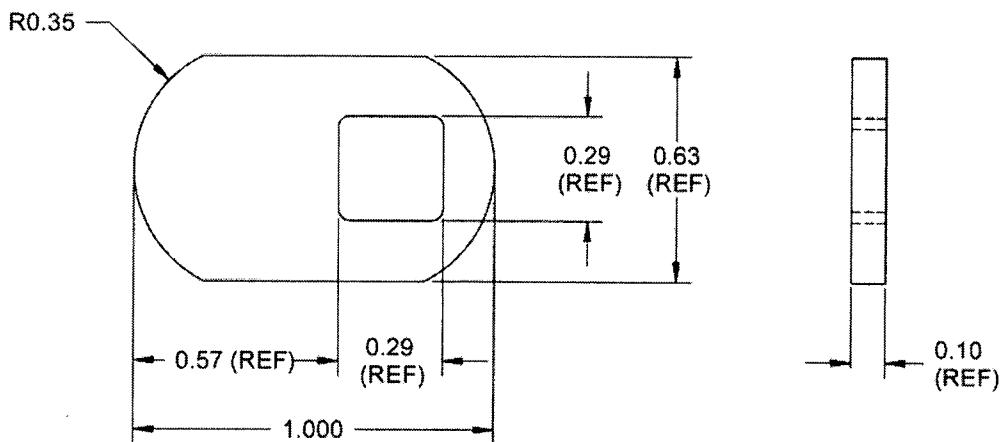
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3371	REV. B SHEET 4 OF 4
DATE	05.03.22	TITLE	PEDAL LOCK	SCALE 2:1

RELEASED  
05/04/28

## SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries